

SPLIT

Work Order ID 159807 -1

159807

Page 1

Wednesday, April 19, 2017 9:53:41 AM

Item ID: 647.2511 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Nut
 Start Date: 4/19/2017 Start Qty: 49.00 *49*
 Required Date: 5/12/2017 Req'd Qty: 49.00 *49* 32 Cust Item ID:
 Reference: RS1035 Rework Customer:

Approvals: Process Plan: [Signature] Date: APR 19 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.2500	A ✓

105

0.00

105

HAAS I

HAAS CNC vertical machine #1

Memo

0.00

PICK FROM STOCK
 647.2511 X49

- B92235 x5
 - B93354 x9
 - B110638 x23
 - M130388 x8

REPASS M11 X 0.75 TAP TO CORRECT TRHEADS
 USE GO-NO GO TOLL

32

P.T.O.

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Quality Control

Memo

0.00

(32)

17.04.19

DAS
 9
 9-89

DC 4: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>159807-1</u> Part No. <u>647-2511</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : _____		Step #: _____		QTY Effective : <u>(32)</u>			MRB (QSI042) Approval																																																																
Description Work Order Deviation <u>B# 647.2511 B93354 9/19 and B110638 9/19/23</u> <u>was inspected and no need for</u> <u>rework</u>				Disposition <u>return in stock with</u> <u>original batch number 159807</u>				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																															
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>						Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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159807

Wednesday, April 19, 2017 9:53:41 AM

Item ID: 647.2511

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Nut

Start Date: 4/19/2017 **Start Qty:** 49.00

49

Cust Item ID:

Required Date: 5/12/2017 **Req'd Qty:** 49.00

49

Customer:

Reference: RS1035

Run Start *NB1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 159807

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 Revision ID: Stop ***NS2***
 Item Name: Nut
 Start Date: 4/19/2017 Start Qty: 49.00 ***49*** Cust Item ID:
 Required Date: 5/12/2017 Req'd Qty: 49.00 ***49*** Customer:
 Reference: RS1035

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>Cck III</u>	0.00							
180									
Packaging	Memo	0.49							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	4.90							
Quality Control									

3 APR 19 2017 DAS
6
9-89

17/4/20 JA

JA

APR 19 2017

Picklist Print

Wednesday, April 19, 2017 9:53:47 AM

Page 1

Work Order ID: 159807

159807

Parent Item: 647.2511

647 2511

Parent Item Name: Nut

Start Date: 4/19/2017

Required Date: 5/12/2017

Start Qty: 49.00

Required Qty: 49.00

Comments: IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.2511 *647 2511* Nut		Manufactured	No				Each	0.0000		49			

**

APR 19 2017

B 9223SXS
93354 X9
110638X23
M130388 XE